





# Work Order ID 62063 - 1

Wednesday, September 15, 2010 2:52:05 PM


Page 1

Item ID: D3572-041 Accept  Setup Start   
Revision ID:  Stop   
Item Name: Guide Assembly  
Start Date: 9/15/2010 Start Qty: 4.00   
Required Date: 9/22/2010 Req'd Qty: 4.00   
Reference: Cust Item ID:  
Customer:

Approvals: Process Plan:  Date: 10-9-15 Tooling:  Date:   
QC: Date: SPC (Y/N): Date: Run Start   
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3572	Rev D

100	Pick Kit	0.00							
									
Packaging	Memo	0.00							
Packaging									

110	Small Fab	0.00							
									
Small Fab	Memo	0.00							
Small Fab	1-Cut Tube D3572-1 as per Dwg D3572 2-deburr both ends								

120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo A1272	0.00							
Quality Control	JH-03								

*rush*

*split 3*

*10-10-15*

*m.l 10/09/29*

*4X*

*4* *1008-30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62063**

Wednesday, September 15, 2010 2:52:05 PM



Page 2

Item ID: D3572-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide Assembly

Start Date: 9/15/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Large Fab

Weld per dwg A/R Aluminum rod Batch: *m114703*  
Large Fab

Memo

0.00

1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572  
2- grind weld flush at the end of tube only*Cpl*

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*3**10/10/18*

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

*10.10.18**3*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Work Order ID 62063

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Item ID: D3572-041

Accept



Setup Start



Revision ID:

Item Name: Guide Assembly

Stop



Start Date: 9/15/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

7) 24 10/10/19

x3

Ø

Memo

0.00

190



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

BL 10-10-19.

M112588

Memo

0.00

3

START TIME: 7:40 32°  
OVEN TEMPERATURE:  
FINISH TIME: 8:10

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

10/10/19 130

Memo

0.00

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Page 4

Item ID: D3572-041

Accept



Setup Start



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Item Name: Guide Assembly

Start Date: 9/15/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

Identify as per dwg & Stock Location: 260

0.00



Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/10/20*

*10/10/20*

*MF*  
*10-10-19*

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# Picklist Print

Wednesday, September 15, 2010 2:52:09 PM

Page 1

Work Order ID: 62063



Parent Item: D3572-041



Parent Item Name: Guide Assembly

Start Date: 9/15/2010

Required Date: 9/22/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-02-07 JLM  
 IPP rev B revB dwg EC  
 IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM  
 IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6T1.000W.188

Purchased

No

110

f

63.5653

2.34

9.852632



6061T6 RD TUBE 1.00 X .188W

Location

Loc Qty

Loc Code

MAT

1.2163

114520

1.2163

MAT016

62.349

113511

15.516

114089 ✓

46.833

D3572-3

Manufactured

No

130

Each

20.0000

4

16



Guide

Location

Loc Qty

Loc Code

ST244

20

59640

20

D3572-5

Manufactured

No

130

Each

25.0000

1

4



Bracket

Location

Loc Qty

Loc Code

ST072

20

59405

20

WA

5

54119

5

*m-l 10/09/29*

*9-852632*

*Cpl 10.10.15*

*15*

*Cpl 10.10.15*

*4*

W/O:		WORK ORDER CHANGES					
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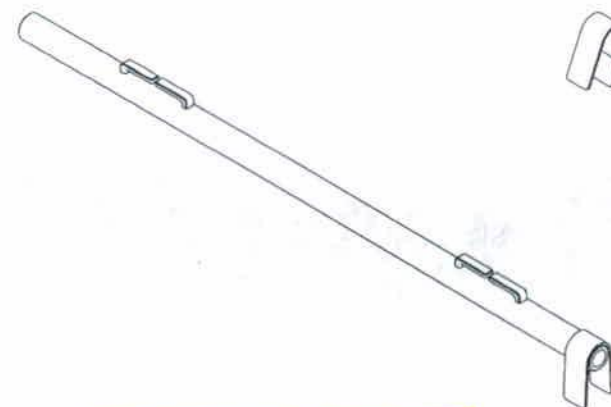
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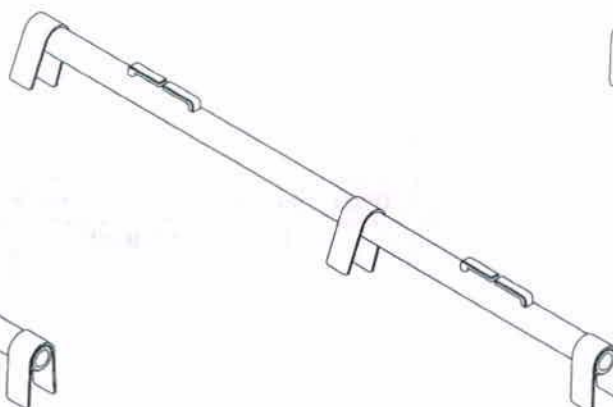
**NOTE:** Date & initial all entries

ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

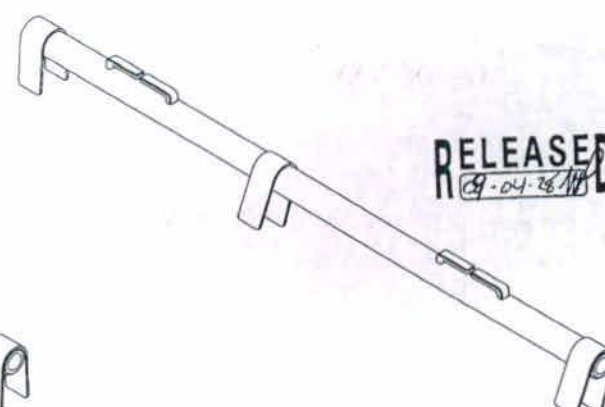
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO APPROVAL  
WITHIN 10 WORKING DAYS  
NO. 42063  
BT 10-9-15



**D3572-041 GUIDE ASSEMBLY**



**D3572-043 GUIDE ASSEMBLY (UH-1)**



**D3572-044 GUIDE ASSEMBLY (UH-1)**

**RELEASED**  
09-04-17

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs  
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS, ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV	DESCRIPTION	BY	DATE
DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	LE	DRAWING NO.	REV. D
MFG. APPR.	LE	D3572	SHEET 1 OF 4
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	GUIDE ASSEMBLY	NTS
DATE	09.04.17	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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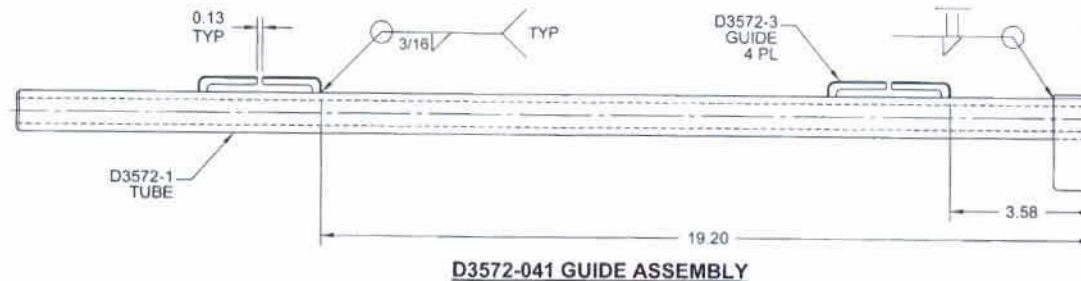
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

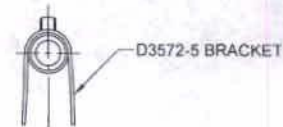
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



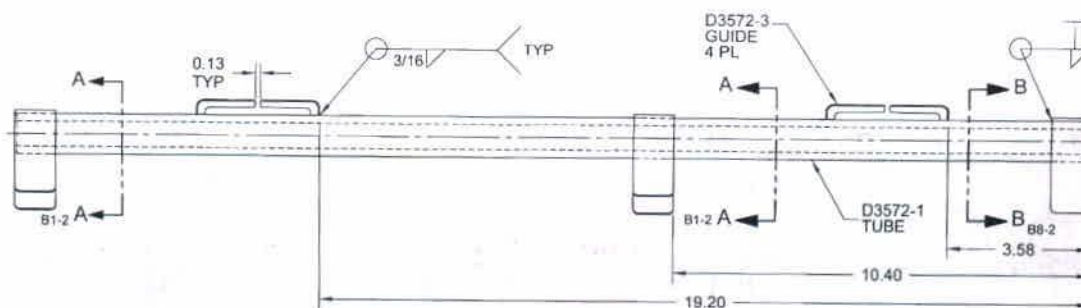


**D3572-041 GUIDE ASSEMBLY**

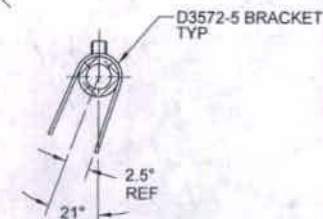


D3572-5 BRACKET

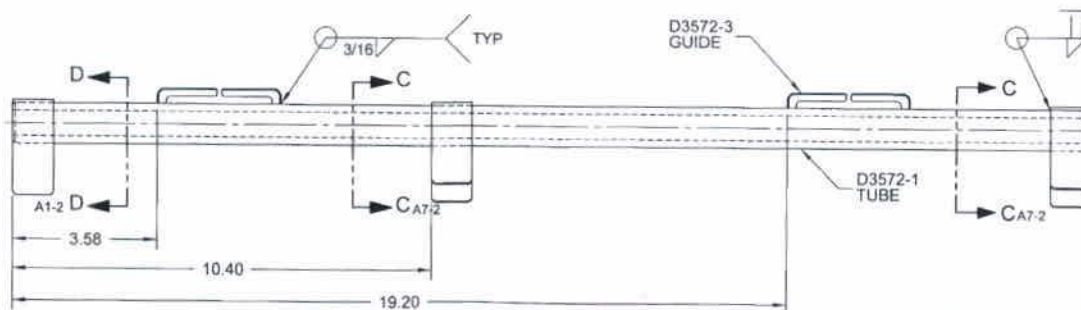
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**D3572-043 GUIDE ASSEMBLY**

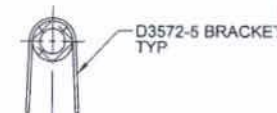


**SECTION A-A** C7-2  
(2 PL) C4-2



**D3572-044 GUIDE ASSEMBLY**

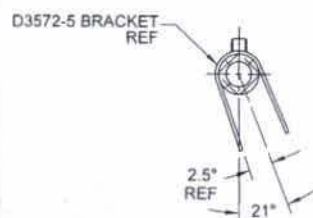
**RELEASED**  
09-04-17



**SECTION D-D** A7-2



**SECTION B-B** C2-2



**SECTION C-C** A2-2  
A5-2

DESIGN	LE	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3572</b>	REV. D
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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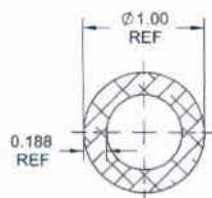
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

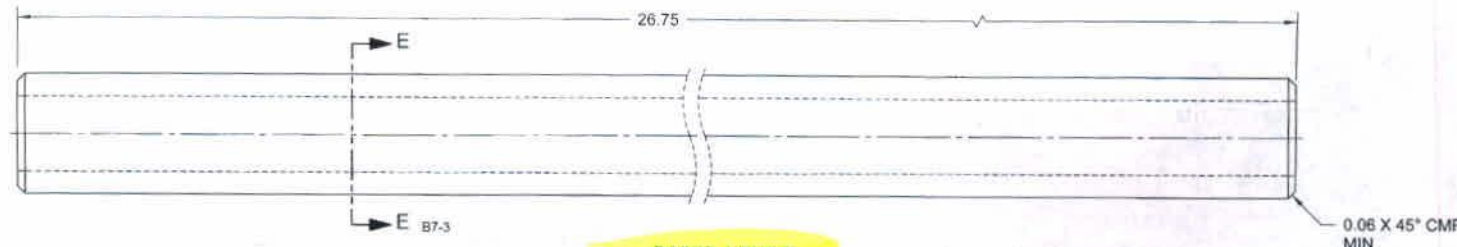
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SECTION E-E C5-3



D3572-1 TUBE

0.06 X 45° CMF MIN

w/o 62063

RELEASED

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8  
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3572	SHEET 3 OF 4
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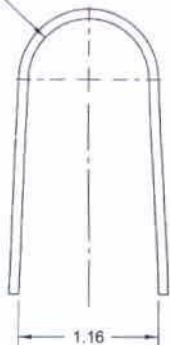
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8 7 6 5 4 3 2 1

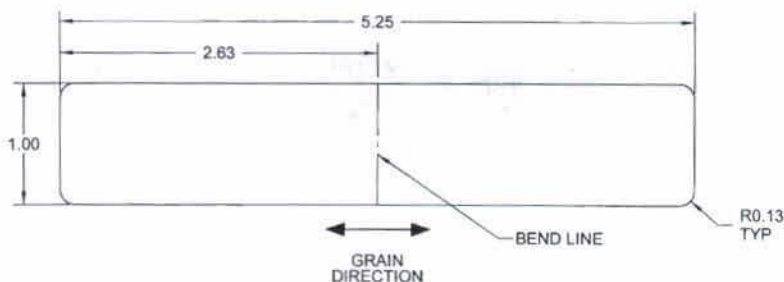
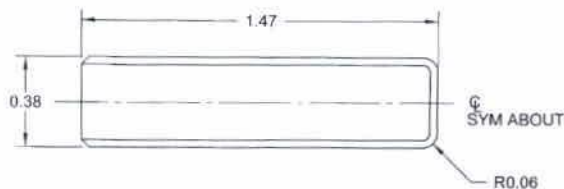
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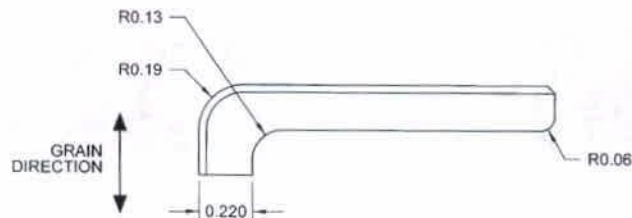
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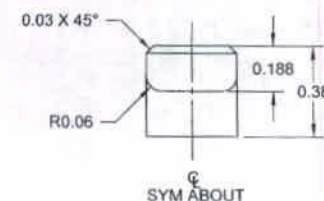
**D3572-5 BRACKET**  
(MAKE FROM D3572-5F)



**D3572-5F FLAT PATTERN**



**D3572-3 GUIDE**



*w/o 62063*

**RELEASED**  
*9/04/17*

**D3572-3 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
AMS-QQ-A-200/8 (OR AMS4160)  
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

**D3572-5 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	LE	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3572	SHEET 4 OF 4
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8 7 6 5 4 3 2 1

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